



BUILDING TRUST



ADEKIT H 9952 BK

H 9952 BK RESIN

H 9952 HARDENER

STRUCTURAL EPOXY ADHESIVE

HIGH AGING RESISTANCE

DESCRIPTION

- High performances two components epoxy adhesive, especially formulated to bond high dimensions surfaces and providing high level of mechanical and aging properties.
- Nano enhanced systems
- Self- extinguishing
- Contains 300µm beads to calibrate adhesive thickness
- High sheer and peel
- Long open time for big parts assembly

PROPERTIES

- High performances assembly
- Bonding of panels: honeycomb, aluminium sheet, stainless-steel sheet, composite materials, wood, thermoplastics, foam...
- Bonding of Carbon & glass epoxy composite, Polyester composite, metal structure

PHYSICAL PROPERTIES				
Composition	RESIN	HARDENER	MIX	METHOD
Mix ratio by weight	100	47	-	
Mix ratio by volume at 25°C	100	50	-	
Aspect	Thixotropic paste	Thixotropic paste	Thixotropic paste	
Colour	Black	Beige	Black	
Viscosity at 25°C, Pa.s (AKP)	145	185	80	LT-001/vit.10
Viscosity at 25°C, Pa.s (AKP)	350	600	230	LT-001/vit.2.5
Density at 25°C (AKP)	1,40	1,30	-	LT-020
Mixed adhesive density at 23°C	-	-	1,38	ISO 2781
Pot life at 23°C on 100g, min (AKP)	-	-	120	LT-002-B

(AKP): Axson Key Properties. These values are enclosed in Certificate Of Analysis.

MECHANICAL PROPERTIES

Hardness, Shore D*	85	ISO 868
Tensile strength, MPa*	42	ISO 527
Elongation at break, %*	3	
YOUNG Modulus, MPa (cured 1H at 80°C)	4000	
Recommended use temperature, °C	15 to 30	-
Working temperature, °C**	-40 to 150	LT-006-B

*Cured 16H at 70°C

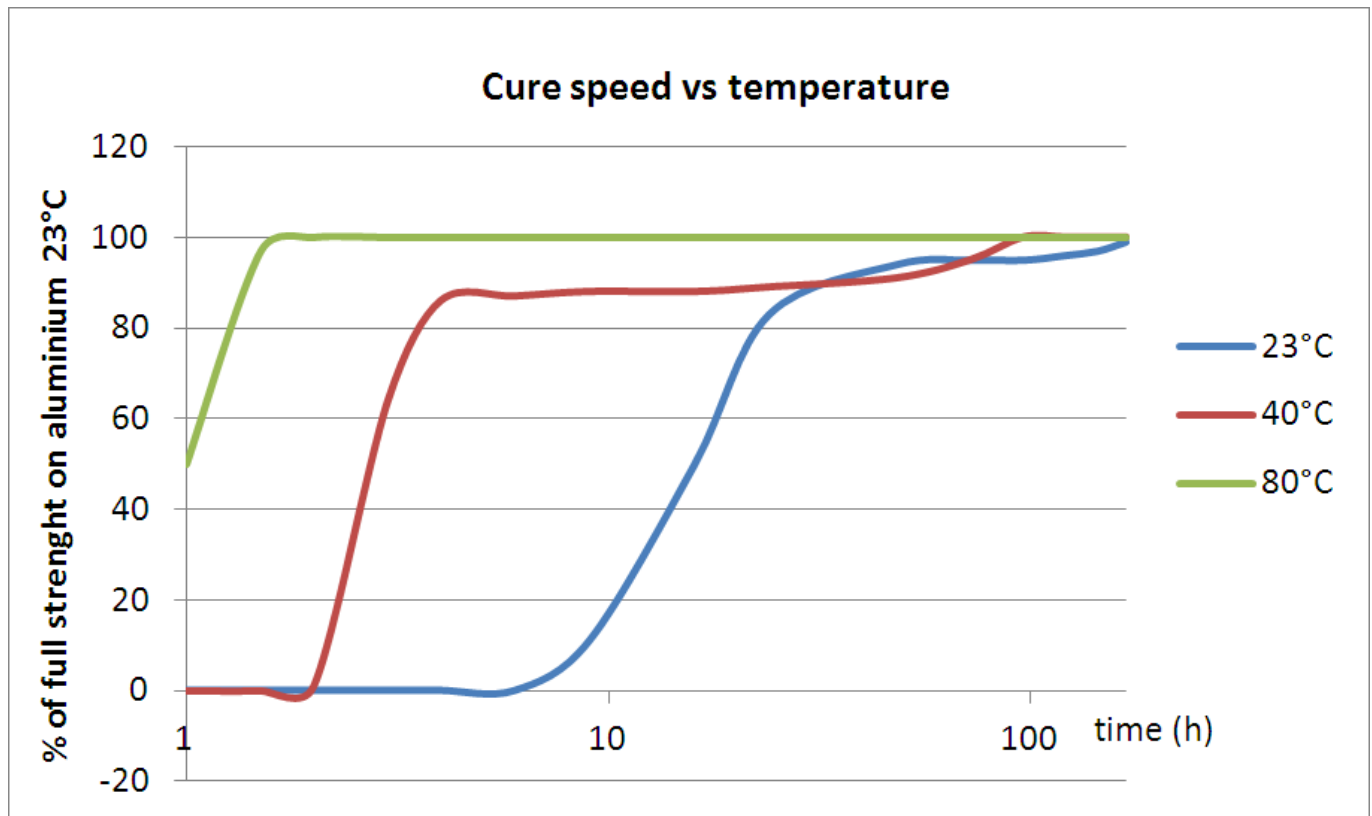
** Working temperature is defined as the temperature at which product keeps 80% of its initial Lap Shear Strength after 1000 hours ageing at this temperature, value on Aluminium, measured at 23°C.

AXSON TECHNOLOGIES Head Office France +33 1 34 40 34 60 axson@axson.com axson.fr	GERMANY +49 (0)7125 940 492 tooling@de.sika.com www.sikaaxson.de	SPAIN & PORTUGAL +34 93 225 16 20 spain@axson.com axson.es	SLOVAKIA +421 37 642 25 26 axson.sk@axson.com axson-ce.sk	USA +1 248 588 2270 axsonmh@axson.com axson-na.com	JAPAN +81 564 26 25 91 sales.japan@axson.com axson.jp	INDIA +91 20 25560710 info.india@axson.com axson.com
	ITALY +39 02 96 70 23 36 axson@axson.it axson.it	U.K. +44 1 638 66 00 62 sales.uk@axson.com axson.com	MEXICO +52 55 52 64 49 22 marketing@axson.com.mx axson.com.mx	CHINA +86 21 58 68 30 37 marketing.china@axson.com axson.cn		

FIRE & SMOKE PROPERTIES

Railway applications - Fire protection on railway vehicles – Part 2 : requirements for fire behavior of materials and components	EN 45545-2	R1 HL3 R2 HL3 R3 HL3 R6 HL3 R7 HL3 R17 HL3
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CURING PERFORMANCE





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HANDLING TIME

Handling time at 23°C	8	H	LT-006-B
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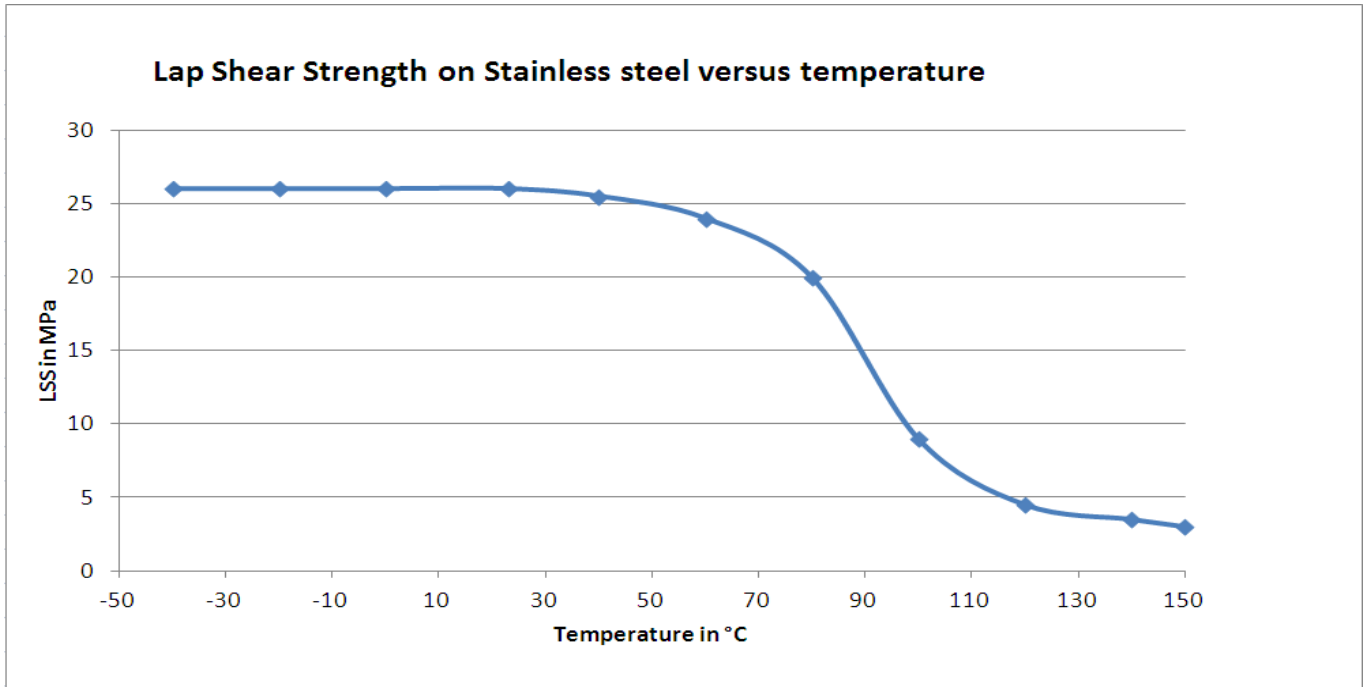
Handling time is defined as the time needed to obtain Lap Shear Strength on Aluminum at 23°C, of 1MPa.

MECHANICAL PROPERTIES ON ASSEMBLIES (Cured 16H at 70°C)

Lap Shear Strength at 23°C				
Aluminium 2017A sandblasted		22 SCF	MPa	LT-006-B
	After 1 week wet cataplastm at 70°C/100% RH	22 SCF		
	After 2 weeks wet cataplastm at 70°C/100% RH	20 SCF		
	After 3 weeks wet cataplastm at 70°C/100% RH	17 SCF		
	After 4 weeks wet cataplastm at 70°C/100% RH	17 SCF		
Stainless Steel 304 sandblasted		25 SCF		
	After 1 week wet cataplastm at 70°C/100% RH	24 SCF		
Electro galvanized steel sandblasted		22 AF		
	After 1 week wet cataplastm at 70°C/100% RH	16 SCF		
Carbon pre-preg Composite Isopropanol wipe		17 SCF		
Polyamide Isopropanol wipe		5 SF		

SCF: Special Cohesive Failure, AF: Adhesive Failure, SF: Substrate Failure, according to EN ISO 10365 Standard.

Floating roller Peel strength at 23°C				
Aluminium 2017A sandblasted		5	KN/m	ISO 4578
	After 1 week wet cataplastm at 70°C/100% RH	4.5		



EQUIPMENT

ADEKIT H9952BK is packaged in 50 ml and 420 ml cartridges and requires a manual or pneumatic gun. Please consult our technical department for applications needing a machine.

SUBSTRATE PREPARATION

The item to be bonded must be free of all dirt, oil or other foreign matter. A clean, dry surface is a must. Please consult our technical support and refer to the technical data sheet about surface preparations to choose adapted degreaser or cleaner.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation
- Wear gloves, safety glasses and waterproof clothes

For further information, please consult the product safety data sheet.



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STORAGE CONDITIONS

Shelf life of ADEKIT H9952BK and H9952BK RESIN / H9952 HARDENER is **24 months** in a dry place and in their original unopened containers at a temperature between 15 and 25°C.

PACKAGING

H9952BK / 50ml	Box of 12 cartridges
H9952BK / 420ml	Box of 12 cartridges
H9952BK RESIN	Pails of 39Kg
H9952 HARDENER	Pails of 37Kg
KIT H9952BK RESIN / H9952 HARDENER	2 X 39Kg + 37Kg

GUARANTEE

The information contained in this technical data sheet result from research and tests conducted in our Laboratories under precise conditions. It is the responsibility of the user to determine the suitability of AXSON products, under their own conditions before commencing with the proposed application. AXSON guarantee the conformity of their products with their specifications but cannot guarantee the compatibility of a product with any particular application. AXSON disclaim all responsibility for damage from any incident which results from the use of these products. The responsibility of AXSON is strictly limited to reimbursement or replacement of products which do not comply with the published specifications.